

Date: Tuesday, 15/07/2008 9:16:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DART 13-MAN 3-POINT SHOULDER HARNESS KIT		
Job Number	: 40497		Part Number	: D412702041B		
Estimate Number	: 12865		Drawing Number	: IIN D412-702 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	15/07/2008	S.O. No. :	Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	30/07/2008	Qty:	1 Um: Each
Previous Run	: 40226					
Written By	:					
Checked & Approved By	: JUD 08.15.08					
Comment	: est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	 Comment: DOCUMENT CONTROL <i>JUD 08.7.21</i> Photocopy bluefile & type labels per PPP D412-702-041B CHG003 <i>S 08/08/</i>
2.0	D412702059	Grommet	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) <i>GROMMET KIT</i> <i>40187</i> <i>JL</i>
3.0	D412702101B	Harness Assembly	 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) <i>Harness Assembly</i> <i>40533</i> <i>JL</i>
4.0	D412702103B	Harness Assembly	 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) <i>Harness Assembly</i> <i>40534</i> <i>JL</i>
5.0	D412702105B	Harness Assembly	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) <i>Harness Assembly</i> <i>40535</i> <i>JL</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	D412702107B	Harness Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HARNESS ASSEMBLY batch: 40536	
7.0	D412702109B	Harness Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HARNESS ASSEMBLY batch: 40537	
8.0	D412702111B	Harness Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) HARNESS ASSEMBLY batch: 40538	18/7/21
9.0	D412702113B	Harness Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) HARNESS ASSEMBLY batch: 40539	18/7/21
10.0	D412702115B	Harness Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HARNESS ASSEMBLY batch: 32491	18/7/21
11.0	D412702117B	Harness Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HARNESS ASSEMBLY batch: 32492	18/7/21
12.0	D35421	Bracket
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) BRACKET batch: 38296	18/7/21 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	D35711	Guide
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)	
	GUIDE batch: 40222	
14.0	D35713	Guide
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	GUIDE batch: B31869	
15.0	D3572041	Guide Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	GUIDE ASSEMBLY batch: 31870	
16.0	D3578041	Doubler
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)	
	DOUBLER batch: B39374	
17.0	D3610041	Bracket
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	BRACKET batch: 38301	
18.0	D36181	CAP
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	CAP batch: 32426	
19.0	AN410A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Bolt batch: M105442	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	AN416A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Bolt	
	batch: M19278	
21.0	AN425A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	BOLT	
	batch: M104438	
22.0	AN444A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	bolt	
	batch: M1044806	
23.0	MS24693S274	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Screw	
	batch: M104217 18 M108560 16	
24.0	MS24694S56	SCREW
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)	
	SCREW	
	batch: M104407	
25.0	MS24694S58	Screw
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Screw	
	batch: M104407	
26.0	MS24694S60	Screw
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Screw	
	batch: M104407	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

27.0 AN960JD416 Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Washer

batch: M10793S

28.0 AN960JD416L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108138

29.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M107478

30.0 CR321244 4-04 CZ Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Cherry Rivet

batch: M108602

31.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

32.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG003

Location: _____

PPP Rev: _____

33.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1		1		D412-702-105B	HARNESS ASSEMBLY
1*	1*		1*		D3573-1	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S273	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT!
WITHOUT NOTICE
WORK ORDER
NO 40497

• COPYRIGHT © 2003 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 07.06.27

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description	Shop Copy	Return To	Engineering	Uncontrolled Copy	Subject To Amendment
2		2			D412-702-111B	HARNESS ASSEMBLY					
1*		1*			D3570-1	BRACKET					
1*		1*			D3579-047	SHOULDER HARNESS					
4*		4*			MS24694S50	SCREW					
4*		4*			AN960JD10L	WASHER					
4*		4*			MS21042L3	NUT					
2		2			D412-702-113B	HARNESS ASSEMBLY					
1*		1*			D3570-2	BRACKET					
1*		1*			D3579-048	SHOULDER HARNESS					
4*		4*			MS24694S50	SCREW					
4*		4*			AN960JD10L	WASHER					
4*		4*			MS21042L3	NUT					
1				1	D412-702-115B	HARNESS ASSEMBLY					
1*				1*	D3573-5	ADAPTER					
1*				1*	D3579-046	SHOULDER HARNESS					
1*				1*	K6.2	CLIP					
4*				4*	MS24693S272	SCREW					
4*				4*	AN960JD10LL	WASHER					
4*				4*	MS21042L3	NUT					
1				1	D412-702-117B	HARNESS ASSEMBLY					
1*				1*	D3573-5	ADAPTER					
1*				1*	D3579-045	SHOULDER HARNESS					
1*				1*	K6.2	CLIP					
4*				4*	MS24693S272	SCREW					
4*				4*	AN960JD10LL	WASHER					
4*				4*	MS21042L3	NUT					
2	2				D3542-1	BRACKET					
7	3		4	1	D3571-1	GUIDE					
2	2				D3571-3	GUIDE					
2		2			D3572-041	GUIDE ASSEMBLY					
12	6		6	2	D3578-041	DOUBLER					
2	2				D3610-041	BRACKET					
2	2				D3618-1	CAP					
4	4				AN4-10A	BOLT					
2		2			AN4-16A	BOLT					
4		4			AN4-25A	BOLT					
2	2				AN4-44A	BOLT					
2	2				MS24693S274	SCREW					
3	3			1	MS24694S56	SCREW					
10	2		8		MS24694S58	SCREW					
1	1			1	MS24694S60	SCREW					
26	6	20			AN960JD416	WASHER	SHOP COPY				
4	4				AN960JD416L	WASHER	RETURN TO				
12	6	6			MS21042L4	NUT	ENGINEERING				
24	12		12	4	CR3212-4-4	RIVET	UNCONTROLLED COPY				

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

WITHOUT NOTICE
WORK ORDER
NO. 40497

• COPYRIGHT © 2003 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 07.06.27

QTY -059	QTY -069	Part Number	Description
X		D412-702-059	GROMMET KIT
X		D412-702-069	GROMMET KIT
48		D3619-1	GROMMET
1		D3619-1T1	HOLE PUNCH
1		D3619-1T2	STRIKER BLOCK
1		D3619-1T3	PUNCH
1		D3619-1T4	DIE
	24	D3619-2	GROMMET
	1	D3619-2T1	HOLE PUNCH
	1	D3619-2T2	STRIKER BLOCK
	1	D3619-2T3	PUNCH
	1	D3619-2T4	DIE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 90497

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 07.06.27